

Date: Friday, 05/09/2008 10:09:45 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 41863		
Estimate Number	: 13052		
P.O. Number	:	Part Number	: D36704200
This Issue	: 05/09/2008 S.O. No. :	Drawing Number	: D3670 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 41615	Material	:
Written By	:	Due Date	: 12/09/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>JUL 08.9.05</u>		
Comment	: Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
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Comment: Qty.: 0.3675 f(s)/Unit Total : 36.7500 f(s)
Material:
(M6061T6T0.313W.058)
Batch: M109240

42 A

SN 08/09/17

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA711& DWG D3670
FOLIO REV: A/A
DWG REV: A

2-DEBURR AS REQUIRED

SN 08/09/17

119

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SN 08/09/17

119

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SN 08/09/17

119

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: Barkley

SN 08/09/17

119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:09:45 AM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 41863

Part Number: D36704200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/18

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

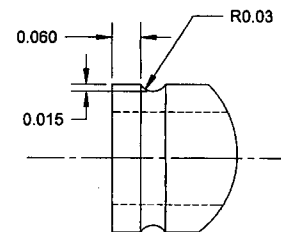
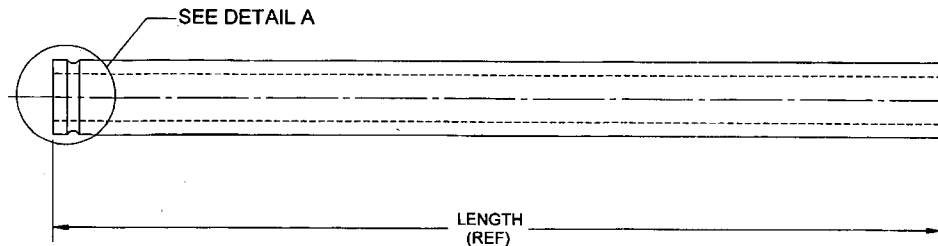
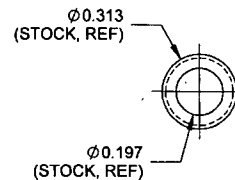
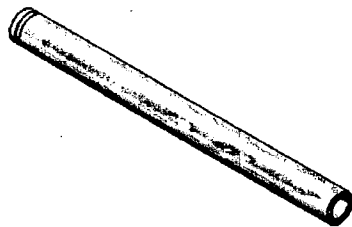
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

A NEW ISSUE		DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	07.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3670
REV. A
SHEET 1 OF 1
TITLE SPACER
SCALE 2:1

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NO. 41803
WORK ORDER
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ENGINEERING
RETURN TO
SHIP COPY